

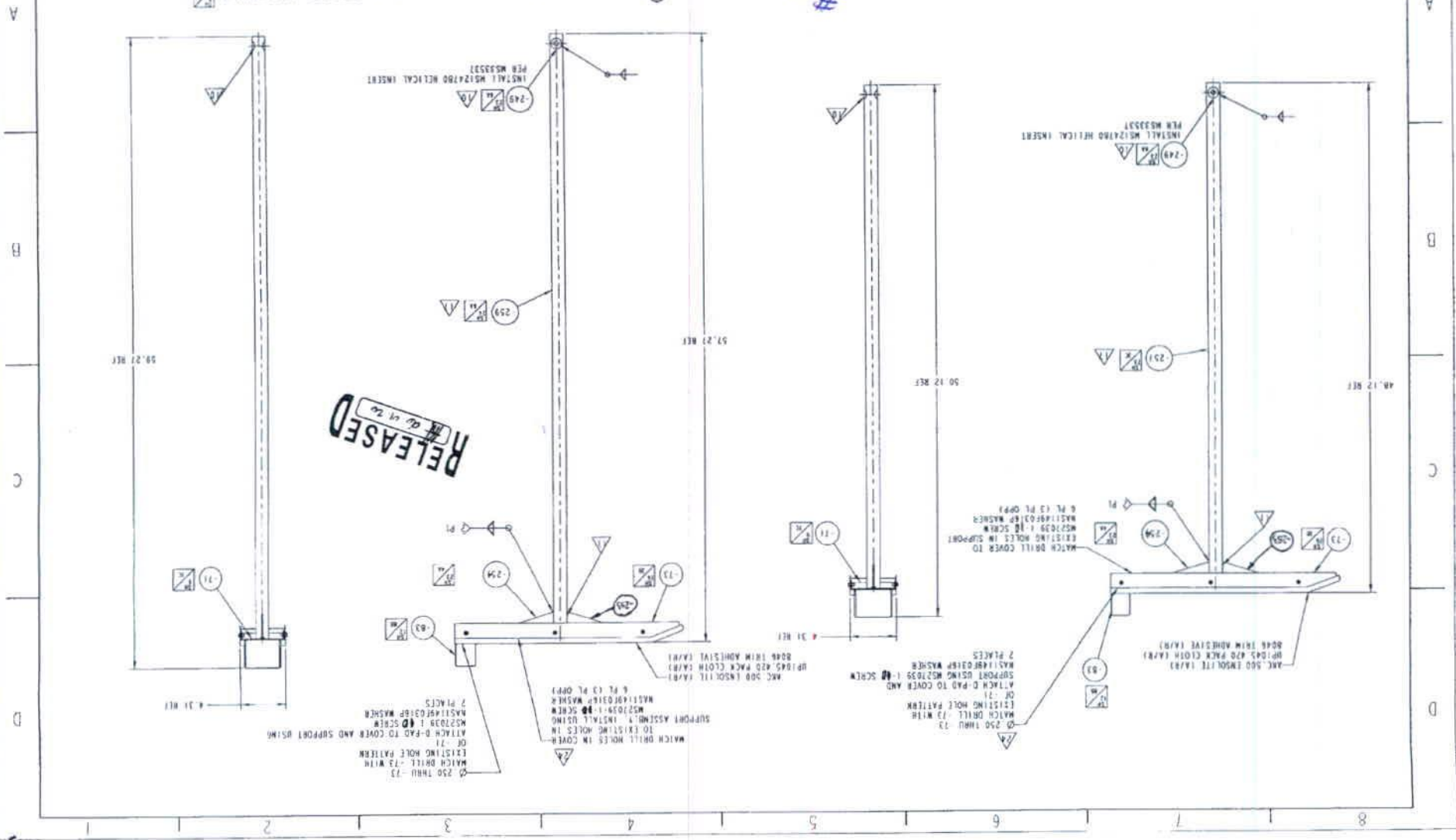
SCALE 0-250

① -17 AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY

SCALE 0.758

① - IS TWO ADJUSTABLE BLADE SUPPORT ASSEMBLY

8090h #



Date: Thursday, 24/07/2008 8:23:49 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (83)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



08-08-26

Date: Thursday, 24/07/2008 8:23:49 AM
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Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40
320 °F
2:10

MP 08/07/31 (5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31 (5)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
20 Degree Cover Plate
batch: 40094

FL 08.08.26 5

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
PB67-43001-83
batch: 40096

FL 08.08.26 5

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)
Screw
batch: 108986

FL 08.08.26 5

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)
WASHER
batch: 108473

FL 08.08.26 5

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- match drill cover to existing holes in support
2- assemble as per dwg

FL 08.08.26 5

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Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

Handwritten: 08-07-24 5

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 080129(5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/7/29 (45)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELICAL INSERT

Handwritten: M 17935

Handwritten: 08-07-30

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

Handwritten: BR 08-07-30

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/6/30 (13)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: u/a S.

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Handwritten: M102316

Handwritten: (5X)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Handwritten: m-h 08/07/31

Heli

Date: Thursday, 24/07/2008 8:23:49 AM
 User: Melanie Fauteux

Process Sheet

Duplicate

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 40608 - 2		
Estimate Number	: 13433		
P.O. Number	:	Part Number	: PB674300115
This Issue	: 24/07/2008 S.O. No. :	Drawing Number	: B6743001 P.7
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 17/07/2008 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 24/07/2008 Qty: 3 Um: Each
Checked & Approved By	: MF 08-07-24		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001257	Inner Tube
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Inner Tube		
batch: 40585		

2.0	PB6743001249	Inner Tube Bushing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Inner Tube Bushing		
batch: m18141		

3.0	PB6743001253	Gusset
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Gusset		
batch: 340045		

4.0	PB6743001254	Gusset
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Gusset		
batch: 340053		

5.0	PB674300171	PB67-43001-71
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
PB67-43001-71		
batch: 340027		